

Date: Monday, 22/12/2008 3:06:33 PM
User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BATTERY LOCK ASSEMBLY
Job Number	: 44258	Part Number	: D3393041
Estimate Number	: 10900	Drawing Number	: D3393 REV A
P.O. Number	:	Project Number	: N/A
This Issue	: 22/12/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Revision	: A
First Issue	: / /	Material	: N/A
Previous Run	: 43420	Due Date	: 20/01/2009
Written By	:	Qty:	4
Checked & Approved By	: <u>JLD 08.12.23</u>	Um:	Each
Comment	: Est Rev:A New Issue 05-11-22 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :								
1.0	D27287	Dart Logo label								
<p>Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)</p> <p>Pick:</p> <table border="1"> <tr> <th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr> <tr> <td>1</td><td>D2728-7</td><td>Decal</td><td>22554</td></tr> </table> <p><i>unable to remove from comp</i> <i>SS 09/01/08</i></p>			Qty	Part Number	Description	Batch	1	D2728-7	Decal	22554
Qty	Part Number	Description	Batch							
1	D2728-7	Decal	22554							
2.0	D33731	Cam Lock								
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)</p> <p>Pick:</p> <table border="1"> <tr> <th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr> <tr> <td>1</td><td>D3373-1</td><td>Cam Lock</td><td>44105</td></tr> </table> <p>***CHECK WITH PRODUCTION IF KEYED ALIKE OR UNALIKE*** <i>SS 09/01/08 (x1)</i></p>			Qty	Part Number	Description	Batch	1	D3373-1	Cam Lock	44105
Qty	Part Number	Description	Batch							
1	D3373-1	Cam Lock	44105							
3.0	516WC	SS Flat Washer 5/16								
<p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)</p> <p>Pick:</p> <table border="1"> <tr> <th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr> <tr> <td>2</td><td>5/16WC</td><td>SS Flat Washer</td><td>M109326</td></tr> </table> <p><i>SS 09/08/08 (x2)</i></p>			Qty	Part Number	Description	Batch	2	5/16WC	SS Flat Washer	M109326
Qty	Part Number	Description	Batch							
2	5/16WC	SS Flat Washer	M109326							
4.0	D33931	Battery Lock Casing								
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)</p> <p>Pick:</p> <table border="1"> <tr> <th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr> <tr> <td>1</td><td>D3393-1</td><td>Battery Lock Casing</td><td>43123</td></tr> </table> <p><i>SS 09/01/08 (x4)</i></p>			Qty	Part Number	Description	Batch	1	D3393-1	Battery Lock Casing	43123
Qty	Part Number	Description	Batch							
1	D3393-1	Battery Lock Casing	43123							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A /	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/12/2008 3:06:33 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BATTERY LOCK ASSEMBLY

Job Number: 44258

Part Number: D3393041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33933

Cam Lock Shaft



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3393-3

Cam Lock Shaft

44108

SS 09/01/08 x4

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.

2-Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-5

3-Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten with lock body nut, apply locktite, then insert lock barrel. Insert D3369-5 fabricated washer and 5/16" SS washer. Thread D3393-3 shaft into lock, then install decal.

A/RN/A262 Locktite

M110005

4-Identify as D3393-041 and attach keys. Ensure that assembly locks and unlocks smoothly. Record the Key

Key Numbers

1- C420A

5- _____

2- C420A

6- _____

3- C420A

7- _____

4- C420A

8- _____

CB
4
09/01/19

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Tack Weld lock shaft to flat cam of a Max 1/8" Long

Qty Part Number Description Batch

A/R N/A

SS Rod

M107051

EL 9-1-21 x4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 44258

Part Number: D3393041

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-01-21

(4)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Apply Crazy Glue to cap and press into Body
9567K21 Batch: M109946

EP 09/01/21

(4)

10.0

9567K21

Polyethelene Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Polyethelene Cap M19102

EP 09/01/21

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 026121 (X4)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 486

SS 09/01/21

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/26

Job Completion



MF 09-01-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

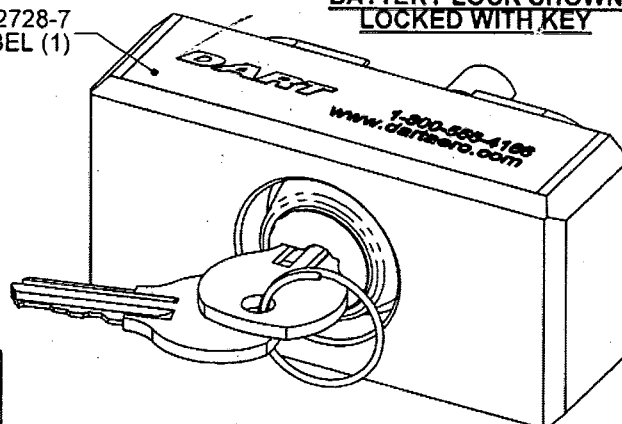
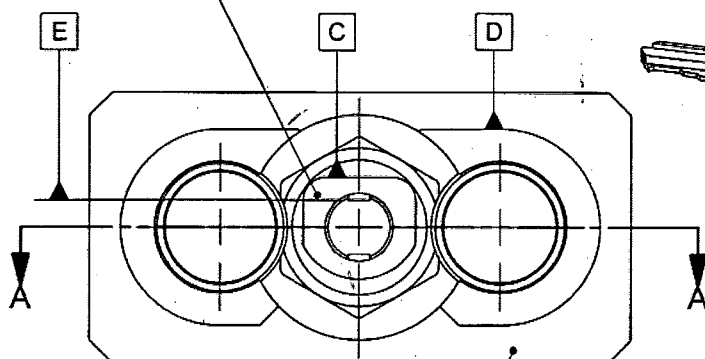
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED TF	APPROVED [Signature]	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED
[Signature]
05/03/09D2728-7
LABEL (1)**BATTERY LOCK SHOWN
LOCKED WITH KEY**POSITION FACE **C** OF D3369-5
PARALLEL TO FACES **D** AND **E**
AS SHOWND3373-1
CAM LOCK
ASSEMBLY (1)D3393-1
CASING (1)Ø 5/16" WC S/S
WASHER (2)

D3369-5 SPACER (1)

PRESS FIT POLYETHYLENE CAP (2) 2
AND APPLY KRAZY GLUED3393-3 CAM
LOCK SHAFT (1)0.09 ^{+0.03} _{-0.01} (2 PLACES)TACK WELD
D3393-3 TO D3369-5**SECTION A-A****D3393-041 BATTERY LOCK ASSEMBLY****NOTES:**

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21.

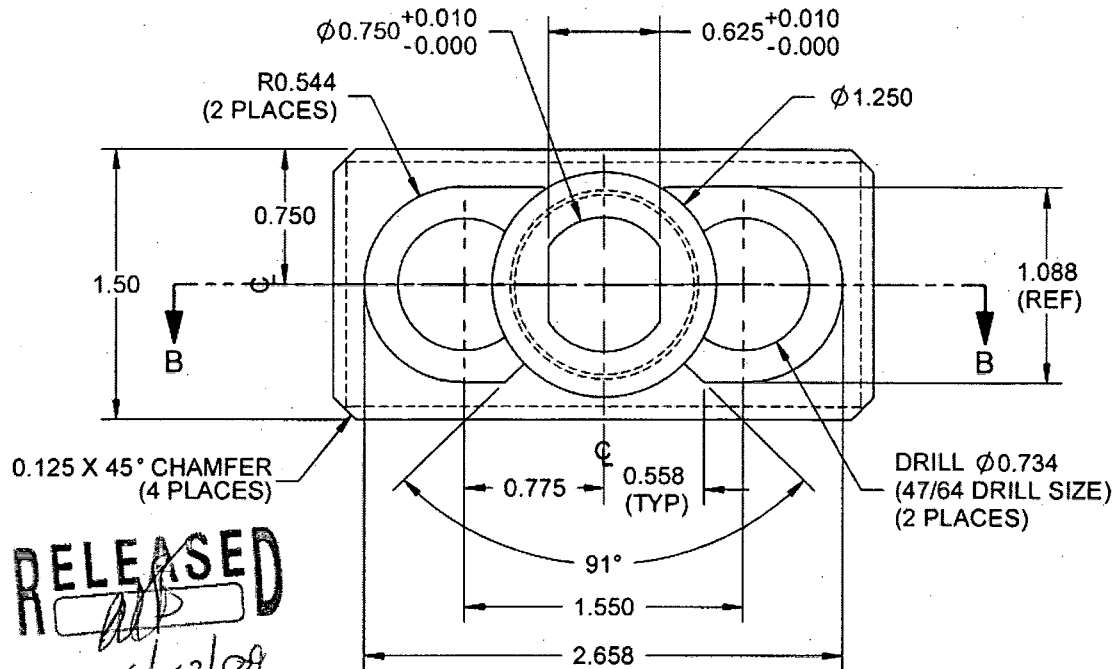
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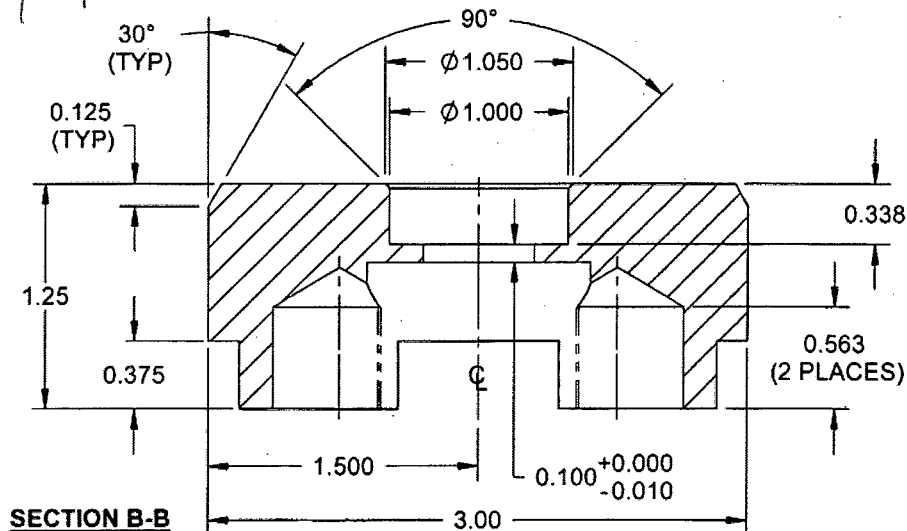
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DART

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CHECKED 17	APPROVED [Signature]	DRAWING NO. D3393	REV. A SHEET 2 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 1:1



RELEASED
05/03/09

**SECTION B-B****D3393-1 CASING****NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

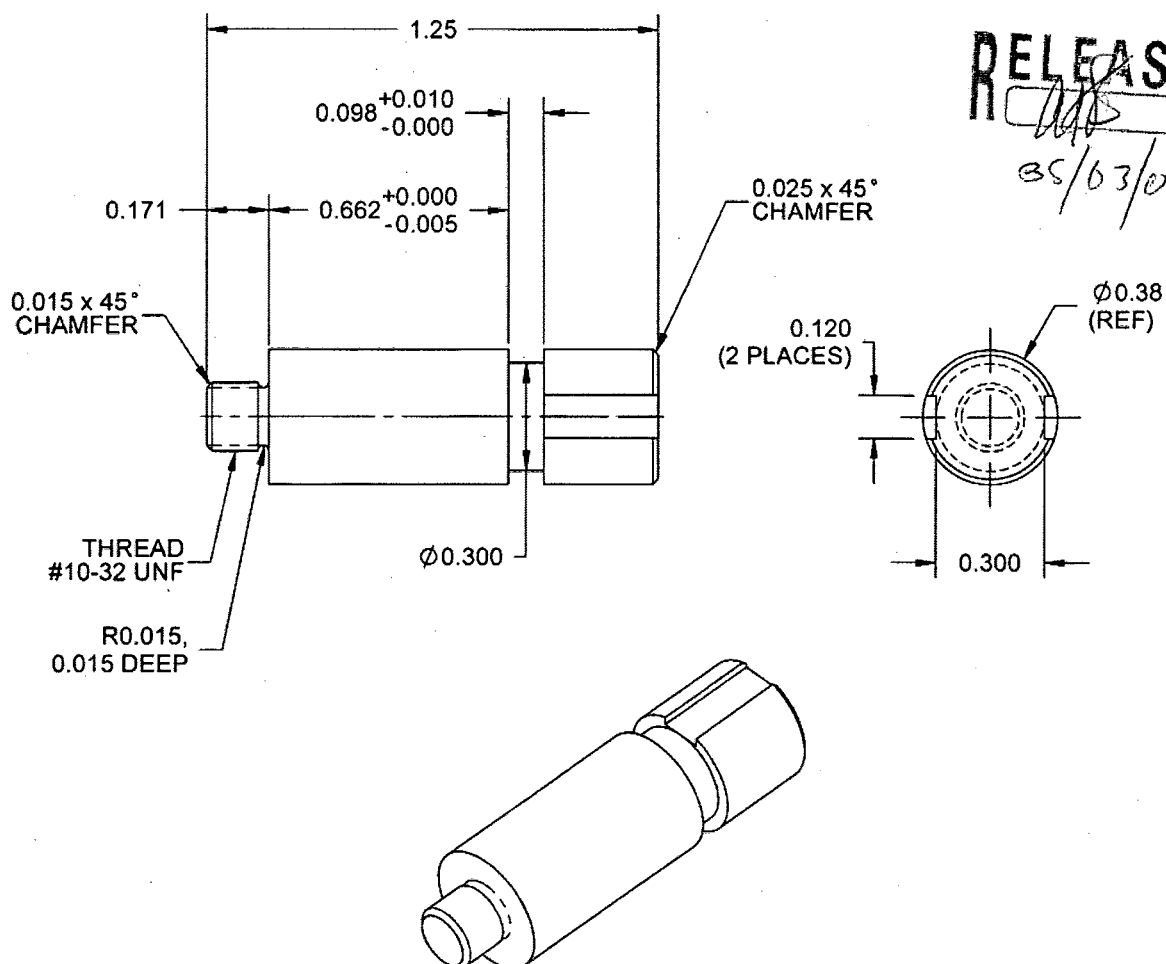
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 3 OF 3
DATE 05.02.09	TITLE BATTERY LOCK		SCALE 2:1

**D3393-3 CAM LOCK SHAFT****NOTES:**

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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